



BOELUBE®



A BOEING DEVELOPED LUBRICANT



The Orelube Corporation
Specialty Industrial Lubricants Since 1958

Introduction:

Under request by one of our customers we proceeded with the following test to determine the amount of **Boelube** lubricant used with Oil Hole Tools. For the test we used the following setup:



To simulate the positive feed drill working scenario the air pressure was regulated to 55-60 PSI and adjusted the amount of lubricant with Unist Piggy-back portable cutter lubricant system.

The cartridge measure 1 cm of length, the equivalent of 5 cc (ml).

Final results:

In approximately 8 min 35 sec, 2 cm or 10 cc (ml) of lubricant was used.



The usage of a Zephyr ZT4000 positive feed drill at 2200 rpm, 0.006 feed rate, drilling 1" thickness of aluminum with 1/2" drill bit diameter results in average drill time of 8-10 sec per hole. Thus, a full cartridge of 15 cc (ml), should drill between 77-97 holes at approx. 1.17 ml/min.